

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011548**Date Inspected:** 14-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Hua Jei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

Bay#13

Lift#11

Segment 11AE-

Welding of internal components, Floor beam, Side plates, Bottom plates, Deck panel Splice and Deck panel diaphragm to Floor beam flange welds are complete. Welding of corner assembly to segment completed. Welding of internal stiffeners of Corner assembly is not complete.

Segment 11BE-

Welding of internal components, Floor beam, Side plates, Bottom plates, Deck panel Splice and Deck panel diaphragm to Floor beam flange welds are complete. Welding of corner assembly to segment completed. Welding of internal stiffeners at FL3 side of Corner assembly is not complete.

Segment 11CE-

Welding of internal components, Floor beam, Side plates, Bottom plates, Deck panel Splice and Deck panel diaphragm to Floor beam flange welds are complete. Welding of corner assembly to segment completed. Welding of internal stiffeners of Corner assembly is not complete.

Segment 11AW-

Welding of internal components, Floor beam, Side plates, Bottom plates, Deck panel Splice and Deck panel diaphragm to Floor beam flange welds are complete. Welding of corner assembly to segment completed. Welding of internal stiffeners of Corner assembly is not complete.

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Segment 11BW-

Welding of internal components, Floor beam, Side plates, Bottom plates, Deck panel Splice and Deck panel diaphragm to Floor beam flange welds are complete. Welding of corner assembly to segment completed. Welding of internal stiffeners at FL3 side of Corner assembly is not complete.

Segment 11CW-

Welding of internal components, Floor beam, Side plates, Bottom plates, Deck panel Splice and Deck panel diaphragm to Floor beam flange welds are complete. Welding of corner assembly to segment completed. Welding of internal stiffeners of Corner assembly is not complete.

Bay#14

Segment 11DE-

Welding of internal components, Floor beam, Side plates, Bottom plates, Deck panel Splice welds are complete. Welding of corner assembly to segment is not completed. Welding of internal stiffeners of Corner assembly is not complete. Deck panel diaphragm and diaphragm to floor beam flange welds are not complete.

Segment 11EE-

Welding of internal components, Floor beam, Side plates, Bottom plates, Deck panel Splice welds are complete. Welding of corner assembly to segment is not completed. Welding of internal stiffeners of Corner assembly is not complete. Deck panel diaphragm and diaphragm to floor beam flange welds are not complete.

Segment 11DW-

Welding of internal components, Floor beam, Side plates, Bottom plates, Deck panel Splice welds are complete. Welding of corner assembly to segment is not completed. Welding of internal stiffeners of Corner assembly is not complete. Deck panel diaphragm and diaphragm to floor beam flange welds are not complete.

Segment 11EW-

Welding of internal components, Floor beam, Side plates, Bottom plates, Deck panel Splice welds are complete. Welding of corner assembly to segment is not completed. Welding of internal stiffeners of Corner assembly is not complete. Deck panel diaphragm and diaphragm to floor beam flange welds are not complete.

Lift#12

Welding is in progress. Fit up of floor beam (FL2) to bottom plates and side plate to bottom plate is in progress.

Bay#14

SMAW welding of weld joint SSD13-PP107-131 located on Segment 11EW. Welder is identified as 051348 (4G). ZPMC QC is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint SSD13-PP108-131 located on Segment 11EW. Welder is identified as 205718 (4G). ZPMC QC is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

FCAW welding of weld joint CA3009-004 located on Segment 12BW. Welder is identified as 201215/202122 (2G). ZPMC QC is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint DP187-001-020, 021 located on Segment 11DW. Welder is identified as 045175 (2F). ZPMC QC is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the

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Applicable WPS-B-T-2132.

FCAW welding of weld joint DP187-001-018, 019 located on Segment 11DW. Welder is identified as 045175 (3F). ZPMC QC is identified as Xu Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2133.

FCAW+SAW welding of weld joint Seg3004AL-010, 008 located on Segment 12AW. Welder is identified as 201215, 048686 (1G). ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-B-U2-F+WPS-B-T-2221-B-L2c-S-2.

FCAW+SAW welding of weld joint Seg3004A-011, 007 located on Segment 12AW. Welder is identified as 201215, 048686 (1G). ZPMC QC is identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-B-U2-F+WPS-B-T-2221-B-L2c-S-2.

Unless otherwise noted, all observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Patel,Hiranch	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
